

RUSH.

**Work Order ID 52191**

September 17, 2009 11:46:32 AM

Page 1

Item ID: D3954-5

Accept

Revision ID: A

Item Name: Chain Lug

Start Date: 09/17/2009 Start Qty: 1.00

Required Date: 09/21/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: MFDate: 09-09-17 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



Mill Conv

Memo

0.00

Conventional Milling Machine

mill to size

AS 090917

110

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3954

Dwg Rev: AProg Rev: A

2-Deburr if necessary

18 9-9-18

②

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 52191

September 17, 2009 11:46:32 AM



Page 2

Item ID: D3954-5

Accept



Setup Start



Revision ID: A

Item Name: Chain Lug

Stop



Start Date: 09/17/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/21/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 9-9-18

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

5/10/09/18

9-9-18 2

2

140

Identify as per dwg & Stock Location: 139C

0.00



Packaging

Memo

0.00

Packaging

9/9/18 @20 SP

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 52191**

September 17, 2009 11:46:32 AM



Page 3

Item ID: D3954-5

Accept



Setup Start



Revision ID: A

Stop



Item Name: Chain Lug

Start Date: 09/17/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 09/21/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/21

ME  
09-09-21

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

September 17, 2009 11:46:32 AM

Page 1

Work Order ID: 52191

Parent Item: D3954-5RevA

Parent Item Name: Chain Lug

Comments:

Start Date: 09/17/2009

Required Date: 09/21/2009

Start Qty: 1.00

Required Qty: 1.00

| Component Item ID/<br>Item Name        | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Remaining<br>Qty To Pick | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M304BT.500X1.500<br>304 bar 1.50 X1.50 |                        | Purchased     | No          |                     |                  | 100             | f                  | 14.2900        | 0.5263                   | 1.0526        |                |        |

B9-9-18

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

14.29

108381

14.29

101741

101741

M1010 9/17/09.09.17.

mild steel.

B# M111410

1010 101741 2.5" X 1"

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                                      |  |                            |
|--------------------------------------|--|----------------------------|
| <b>DART AEROSPACE LTD</b>            |  | <b>Work Order:</b> 52194   |
| <b>Description:</b> RATCHET LUG      |  | <b>Part Number:</b> D39549 |
| <b>Inspection Dwg:</b> D39549 Rev: A |  | Page 1 of 1                |

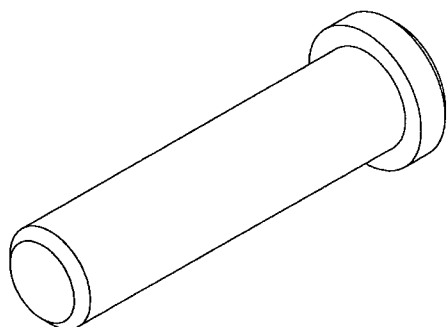
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

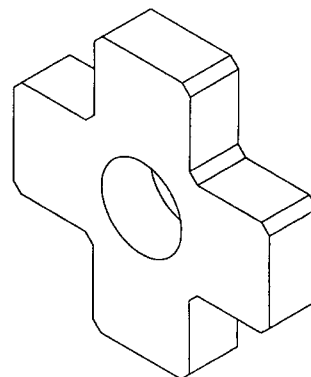
| Drawing Dimension | Tolerance        | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|------------------|------------------|--------|--------|----------------------|----------|
| Ø .75             | + .010 - .001    | .754             | X      |        |                      |          |
| 1.00              | ± .030           | .994             | *      |        |                      |          |
| .385              | + .025 - .000    | .388             | *      |        |                      |          |
| .31               | ± .030           | .301             | *      |        |                      |          |
| .25               | ± .030           | .258             | *      |        |                      |          |
| 1.06              | ± .030           | 1.06             | ✓      |        |                      |          |
| 2.63              | ± .030           | 2.647            | ✓      |        |                      |          |
| 3.25              | ± .030           | 3.259            | ✓      |        |                      |          |
| 5.250             | ± .010           | 5.250            | ✓      |        |                      |          |
| 6.00              | ± .030           | 6.001            | ✓      |        |                      |          |
| .88               | ± .030           | .879             | ✓      |        |                      |          |
| Ø .375            | + .005<br>- .001 | .376             | —      |        |                      |          |
| R .185            | + .010           | R .1875          | —      |        |                      |          |
| .12               | ± .030           | .12              | —      |        |                      |          |
| .750              | ± .010           | .753             | —      |        |                      |          |
|                   |                  |                  |        |        |                      |          |
|                   |                  |                  |        |        |                      |          |
|                   |                  |                  |        |        |                      |          |
|                   |                  |                  |        |        |                      |          |
|                   |                  |                  |        |        |                      |          |
|                   |                  |                  |        |        |                      |          |
|                   |                  |                  |        |        |                      |          |
|                   |                  |                  |        |        |                      |          |
|                   |                  |                  |        |        |                      |          |
|                   |                  |                  |        |        |                      |          |
|                   |                  |                  |        |        |                      |          |
|                   |                  |                  |        |        |                      |          |

|                        |                       |                            |     |
|------------------------|-----------------------|----------------------------|-----|
| <b>Measured by:</b> HB | <b>Audited by:</b> SA | <b>Prototype Approval:</b> | N/A |
| <b>Date:</b> 9-9-18    | <b>Date:</b> 09/09/18 | <b>Date:</b>               | N/A |

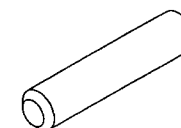
| Rev | Date | Change    | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A   |      | New Issue | KJ/JLM     |          |



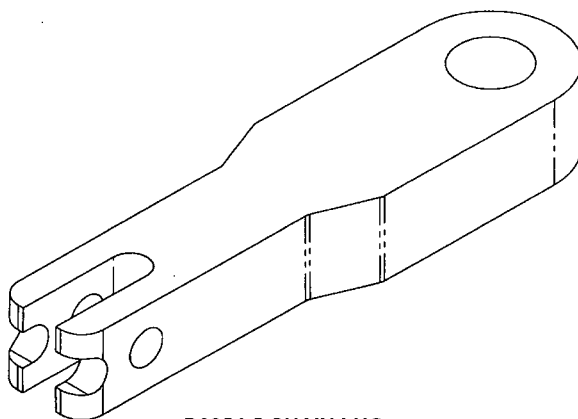
**D3954-1 GWT PIN**



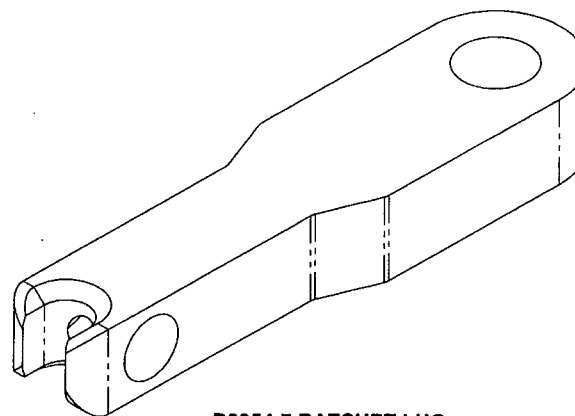
**D3954-3 GWT KNOB**



**D3954-9 GWT CHAIN PIN**



**D3954-5 CHAIN LUG**



**D3954-7 RATCHET LUG**

52191  
**RELEASED**  
04/06/02-108

|            |           |  |  |  |          |
|------------|-----------|--|--|--|----------|
| A          |           | NEW ISSUE  |  | AJS  | 09.05.26 |
| REV.       |           | DESCRIPTION  |  | BY   | DATE     |
| DESIGN     | AJS/DSTOW | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |  | REV. A   |          |
| DRAWN      | AJS       |  |  | SHEET 1 OF 3   |          |
| CHECKED    |           | DRAWING NO. <b>D3954</b>                                 |  | TITLE  |          |
| MFG. APPR. |           |  |  | SCALE  |          |
| APPROVED   |           |  |  | MISC MACHINED PARTS GWT KIT  |          |
| DE APPR.   | N/A       |  |  | NTS  |          |
| DATE       | 09.05.26  |  |  | <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD<br/>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> |          |

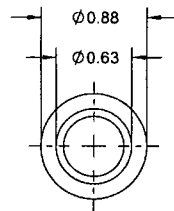
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

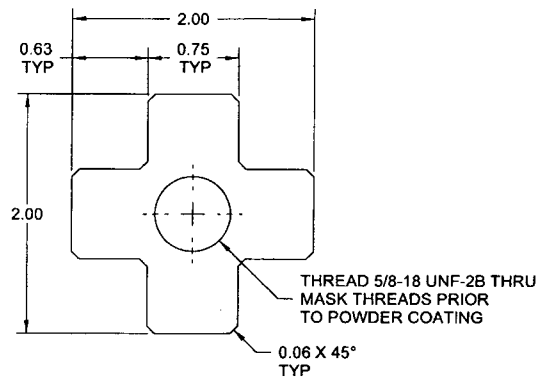
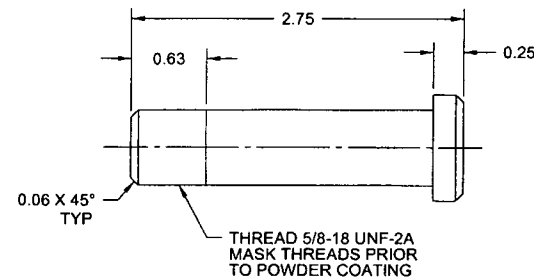
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

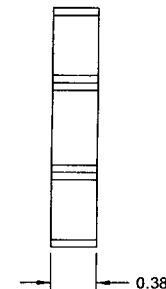
NOTE: Date & initial all entries



**D3954-1 GWT PIN**



**D3954-3 GWT KNOB**



**NOTES:**

1) MATERIAL -1: AISI 303/304 STAINLESS STEEL ROUND BAR  
REF DART SPEC M303/304R

-3: AISI 303/304 STAINLESS STEEL SHEET  
PER AMS 5513 OR AMS 5524  
REF DART SPEC M303/304S

OR: AISI 303/304 STAINLESS STEEL BAR  
REF DART SPEC M303/304B

2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -1: 0.26 lbs

-3: 0.23 lbs

52191

**RELEASED**  
09/05/02

|            |           |  |              |
|------------|-----------|--|--------------|
| DESIGN     | AJS/D3TOW | <b>DART AEROSPACE LTD</b>  |              |
| DRAWN      | AJS       | HAWKESBURY, ONTARIO, CANADA  |              |
| CHECKED    |           | DRAWING NO.  | REV. A       |
| MFG. APPR. |           | <b>D3954</b>   | SHEET 2 OF 3 |
| APPROVED   |           | TITLE  | SCALE        |
| DE APPR.   | N/A       | <b>MISC MACHINED PARTS GWT KIT</b>   |              |
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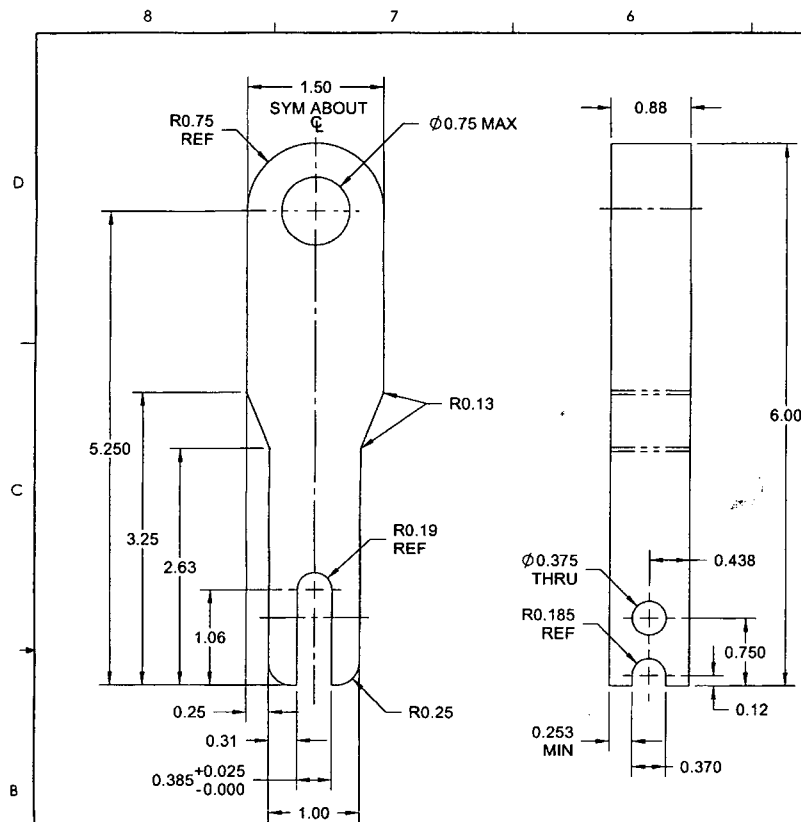
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

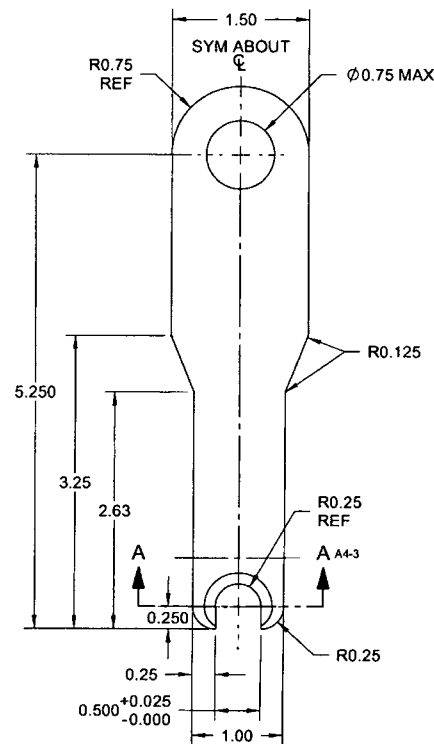
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

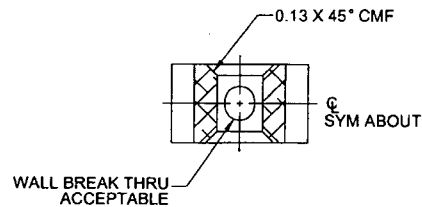
NOTE: Date & initial all entries



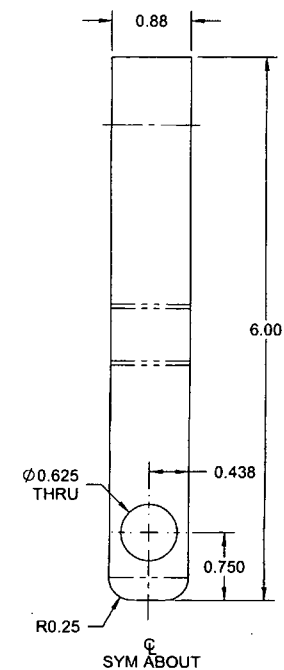
**D3954-5 CHAIN LUG**



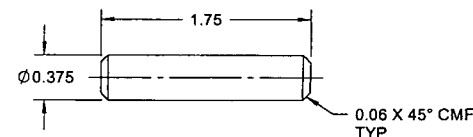
**D3954-7 RATCHET LUG**



**SECTION A-A** C3-3



**D3954-9 GWT CHAIN PIN**



**NOTES:**

1) MATERIAL -5/-7: AISI 303/304 STAINLESS STEEL BAR  
REF DART SPEC M303/304B

-9: AISI 303/304 STAINLESS STEEL ROUND BAR  
REF DART SPEC M303/304R

2) FINISH -7 ONLY: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED


5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3954-X" USING FINE POINT PERMANENT INK MARKER

7) WEIGHT -5/-7: 1.56 lbs EACH

-9: 0.05 lbs

**RELEASED**  
07/08/02

|  |   |  |              |
|--|---|--|--------------|
| DESIGN   | AJS/DSTOW   | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN  | AJS   | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED  |  | DRAWING NO.                            | REV. A       |
| MFG. APPR.   |   | D3954                                  | SHEET 3 OF 3 |
| APPROVED   |   | TITLE                                  | SCALE        |
| DE APPR.   | N/A   | MISC MACHINED PARTS GWT KIT            | NTS          |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries